

Date: Monday, 9/10/2007 1:31:17 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARSHOE
Job Number	34510		
Estimate Number	10618		
P.O. Number	N/A	Part Number	D265637
This Issue	9/10/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D2656 REV D
First Issue	N/A	Project Number	N/A
Previous Run	33217	Drawing Revision	D
Written By		Material	N/A
Checked & Approved By	<u>KJ 07-09-11</u>	Due Date	10/10/2007
Comment	Est Rev: D 02.10.25 Re-format KJ Est Rev: E 06-06-12 Now on Waterjet JLM		
Qty: <u>40</u> Um: Each			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S20GA	1010/1025/A21/6aA SHEET
Comment: Qty.: 0.5650 sf(s)/Unit Total : 11.3001 sf(s) 1010/1025 .040" SHEET (M1010S20GA) Batch: <u>M105621</u> <u>BS 07-09-24</u> <u>M100473</u> <u>7 pieces!</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2656 Dwg Rev: <u>D</u> <u>BS 07-09-24</u> Prog Rev: <u>D</u> 2-Deburr if necessary <u>BS 07-09-24</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>BS 07-09-24</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>En 310725</u> cont'd		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary.		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE	CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/09/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:31:18 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 34510

Part Number: D265637

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261and DT8326.

2- Identify as D2656-37

SB 07/09/25

40

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Fr 07/09/25 640

Canto

8.0 POWDER COATING POWDER COATING



m104846

40

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Fx 07/09/25

40

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

el 07-09-27

40

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-16

Fx 07/09/27

40

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

22071091asg

40

Job Completion



(Y)07/09/27

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34510
Description: Wearshoe	Part Number:	D2656-37
Inspection Dwg: D2656 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

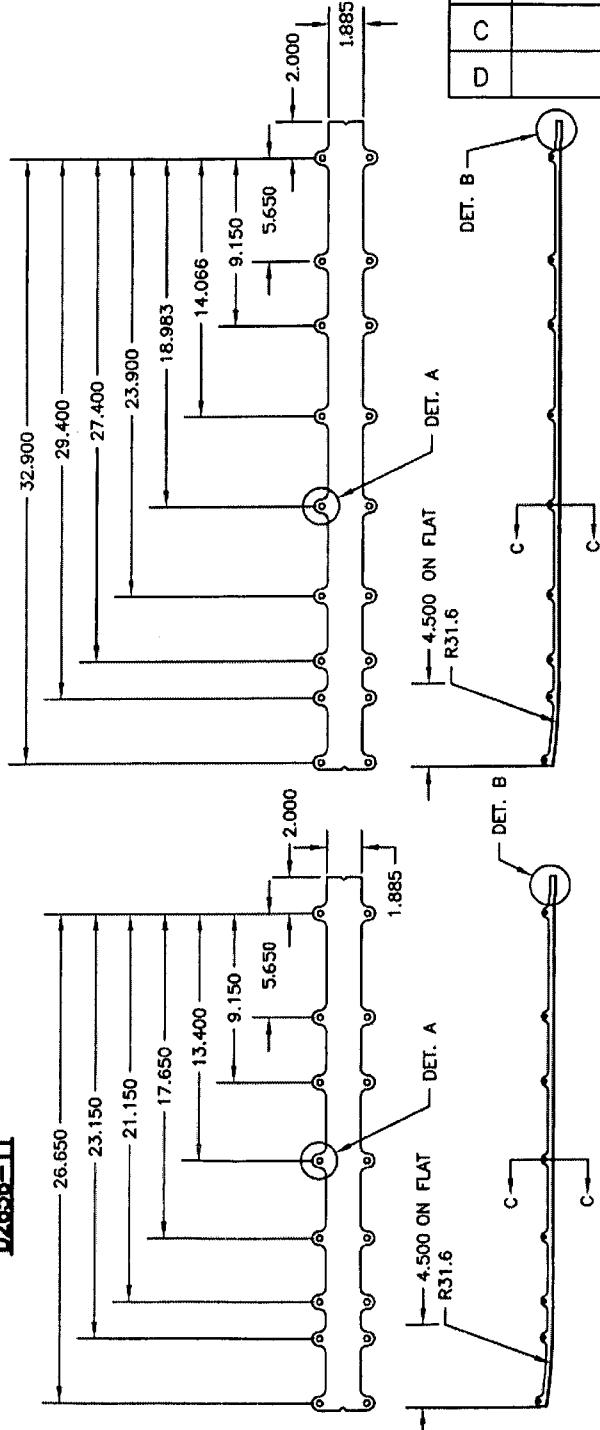
Measured by:	B	Audited by:	C	Prototype Approval:	N/A
Date:	07-09-25	Date:	07/09/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.07.07	New Issue	KJ/JLM	E

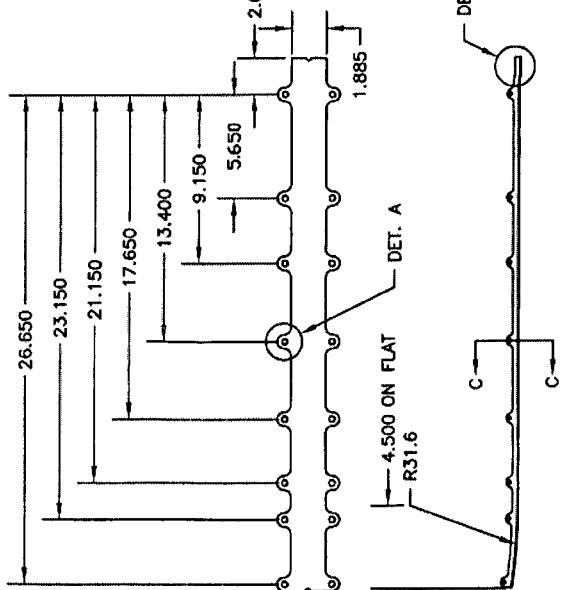
DART

DESIGN CHECKED	DRAWN BY APPROVED	DART AEROSPACE USA, INC. PORT HADLOCK, WA
		DRAWING NO. D2656
DATE 05.08.17	TITLE WEARSHOE	REV. D SCALE 1:10
A B C D	97:03:25 97:06:02 97:06:26 05.08.17	NEW ISSUE CHANGED TABS R31.6 WAS R19.5 ENLARGE ALL HOLES TO IMPROVE FIT

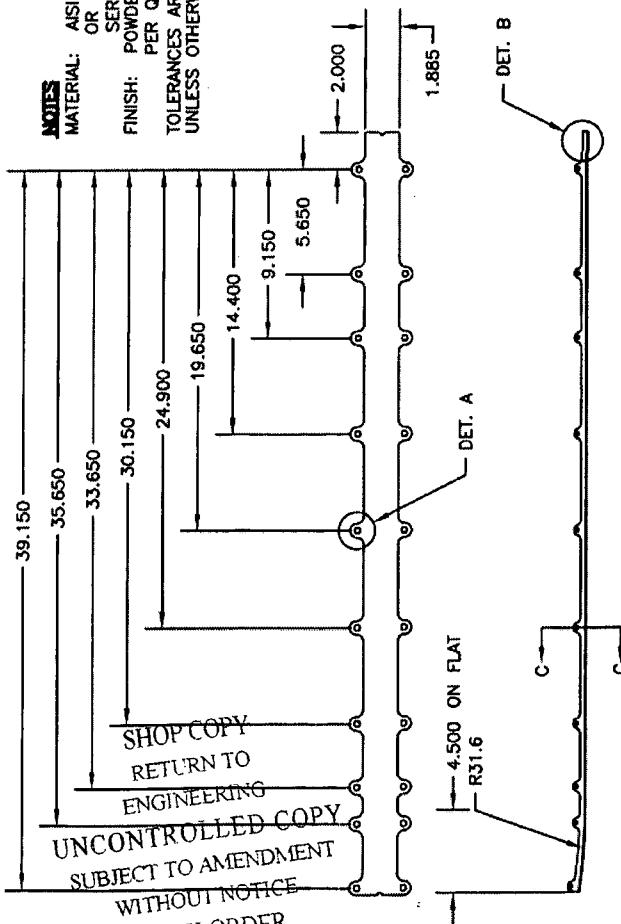
D2656-13



D2656-11

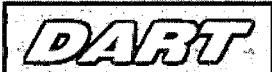


D2656-15



NOTES
MATERIAL: AISI 1010-1025 OR ASTM A36/A36/A1008
OR CSA G40-21, 3BW/44W/50W/60W/70W
SERIES STEEL 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

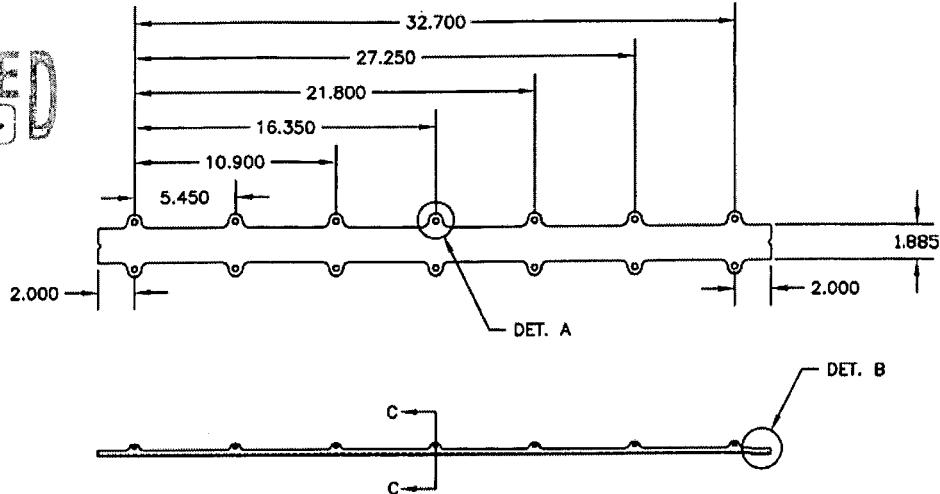
RELEASED
05.09.08 *[Signature]*



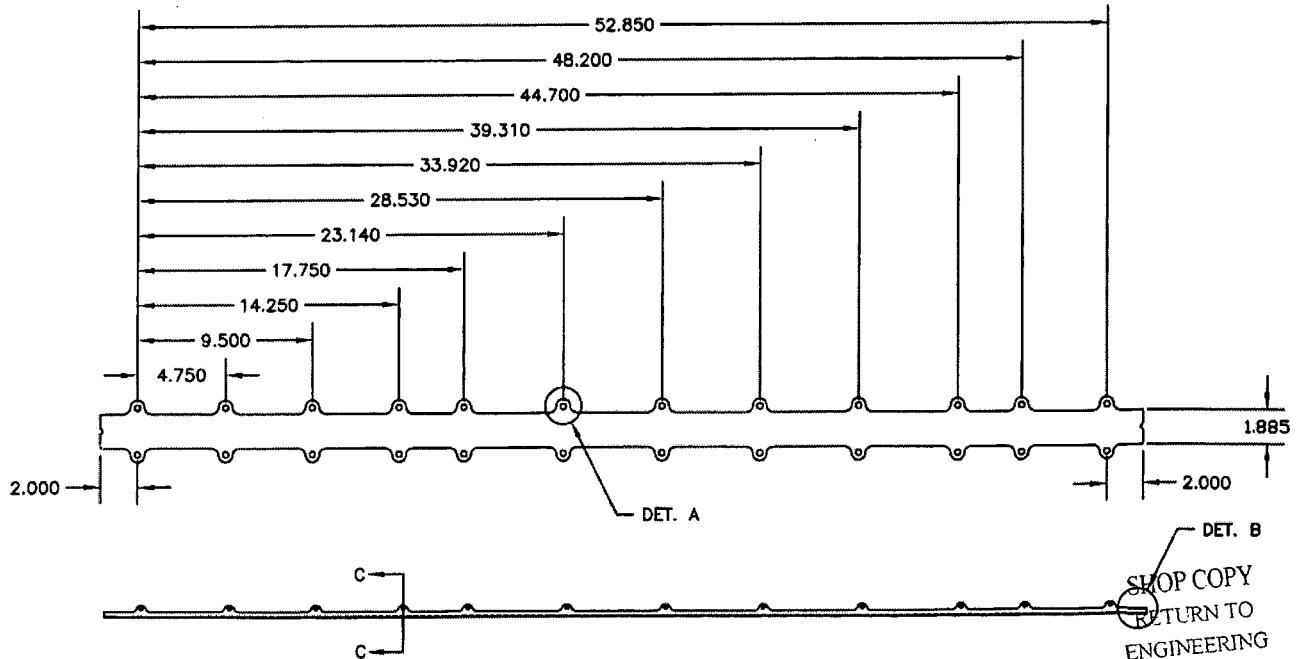
DESIGN DS	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656
DATE 05.08.17		REV. D SHEET 2 OF 4 TITLE WEARSHOE SCALE 1:10

D2656-21

RELEASED
05.07.06 *[Signature]*



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *34510*

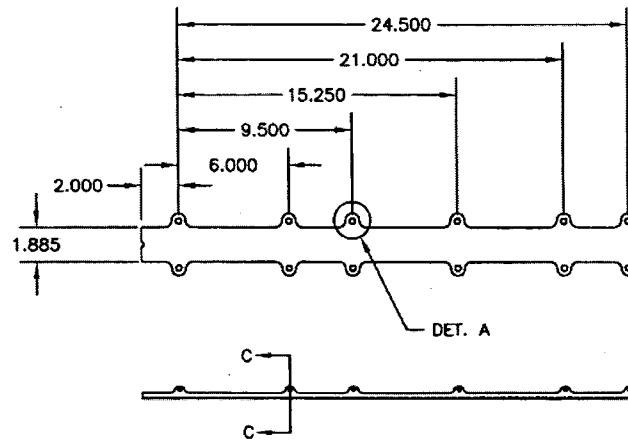
Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

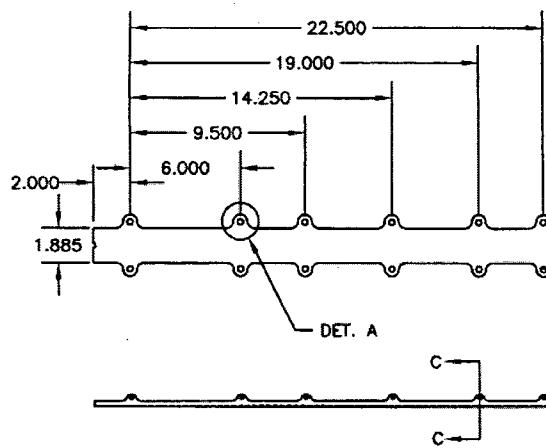
DART

DESIGN	DS	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>MM</i>	APPROVED	<i>MM</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DATE	05.08.17	DRAWING NO.	D2656	REV. D SHEET 3 OF 4 SCALE 1:10
TITLE	WEARSHOE			

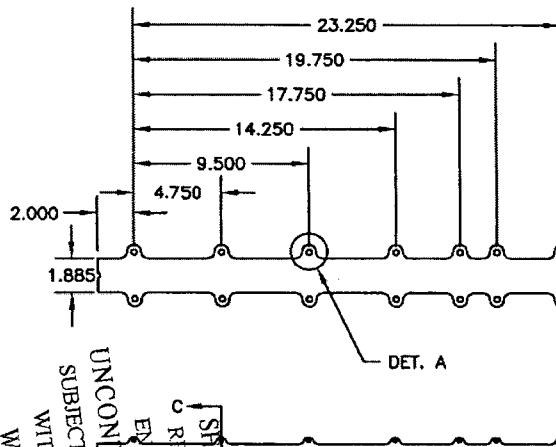
D2656-33



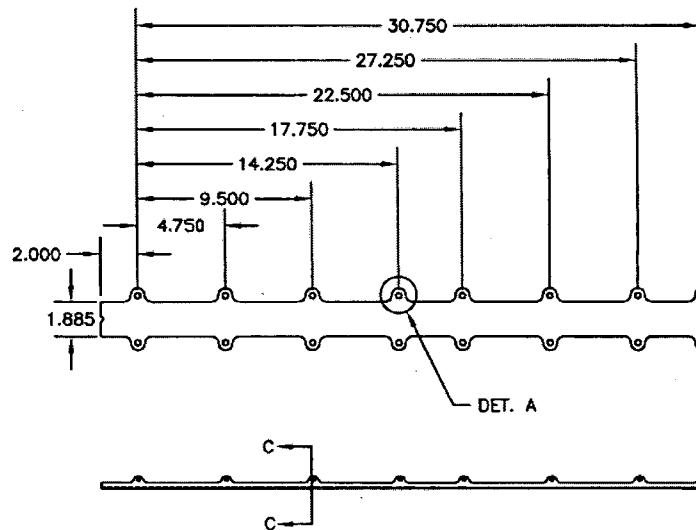
D2656-31



D2656-35



D2656-37



RELEASED
05.07.06
MM

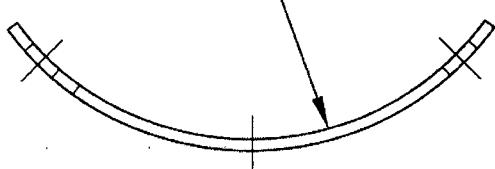
UNCONTROLLED
NOTES
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
WITHOUT NOTICE
WORK ORDER
300



DESIGN DS	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656	REV. D SHEET 4 OF 4
DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

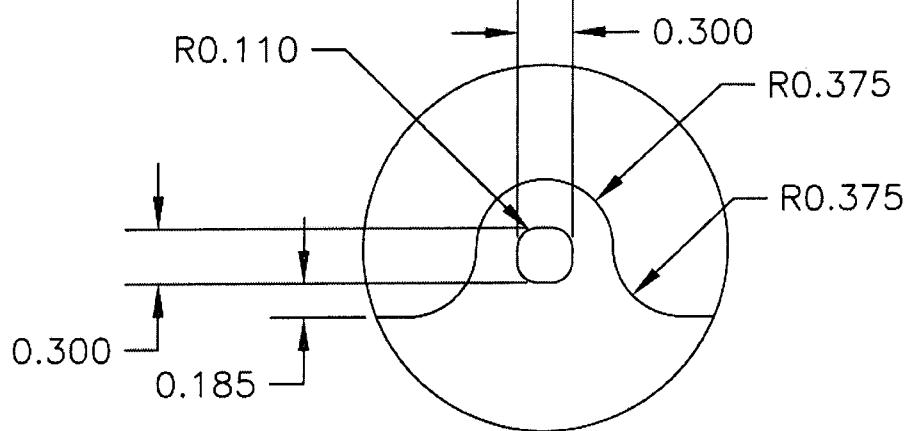
SECTION C-C

R1.62

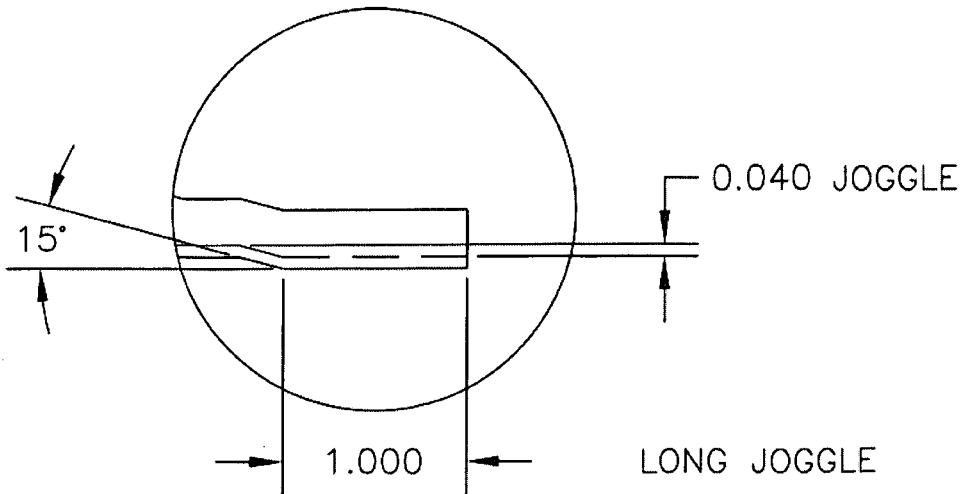


RELEASED
05.09.06 *[Signature]*

DETAIL A



DETAIL B



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *34510*

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.